

Work Order ID 147543

Thursday, June 09, 2016 8:51:49 AM

147543

Page 1

Item ID: D2534 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lock Plate
 Start Date: 6/13/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 6/15/2016 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MJS Date: JUN 13 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2534	Rev D								
100	FLOW WATER JET	0.00							PR 2016/08/20 DAS 14 9-09 16/08/22
100									
Waterjet	Memo	0.10							
FLOW CNC Waterjet	1-Cut as per Dwg D2734 Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.03							
Quality Control									20 PR 2016/08/20 DAS 14 9-09 16/08/22
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.07							
Quality Control									20 DAS 38 AUG 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Page 2

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Item Name: Lock Plate
Start Date: 6/13/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 6/15/2016 Req'd Qty: 20.00 ***20*** Customer:
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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.03							
Packaging	*****STOCK IN LARGE FAB***** LOCATION WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.33							
Quality Control									

DAS
6
9-89DAS
21
9-89

AUG 23 2016

DAS
21
9-89

AUG 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, June 09, 2016 8:51:52 AM

Page 1

Work Order ID: 147543

147543

Parent Item: D2534

D2534

Parent Item Name: Lock Plate

Start Date: 6/13/2016

Required Date: 6/15/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
IPP Rev:B Now on Waterjet 06-06-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			110	sf	107.2349	0.0427	0.898948			

M304S11GA

304/316 0.125 Sheet

PR 2016/08/20
DAS
14/16/08/22
9-33

Location	Loc Qty	Loc Code
MAT020	80.99998	
M129545	31.99998	
M129972	23.5	
M134284	25.5	
TPI	26.234932	
M134604	26.234932	
M135355		

1.6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

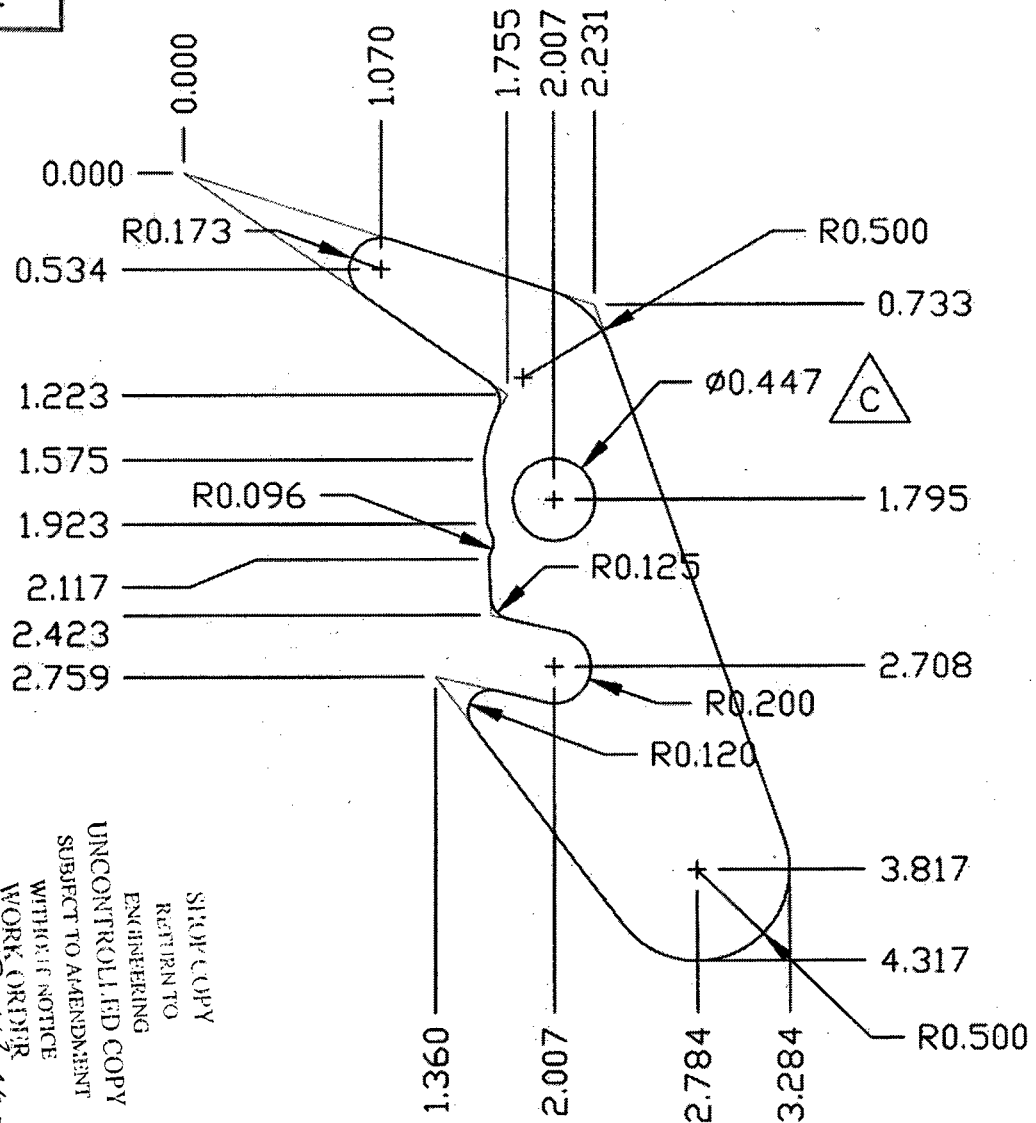
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
S								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO. D2534	REV. D SHEET 1 OF 1
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	TITLE LOCK PLATE	SCALE 1:1
DATE 04.12.14			
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]*

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 179543 M05
1626-13

D2534 LOCK PLATE

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED